

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008544**Date Inspected:** 28-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang HAO**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress

BAY#10

FCAW welding process of weld joint 2A located on PCMK NSD1-TL8B/L. Welder is identified as 040261 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-C-U2-F.

FCAW welding process of weld joint 8 located on PCMK NSD1-SA166B/F. Welder is identified as 040533 ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2331-TC-P4-F.

SAW welding process of weld joint 3A located on PCMK NSD1-TL8B/L. Welder is identified as 040489 ZPMC QC is identified as Li Ming. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S2.

SAW welding process of weld joint 16A located on PCMK SSD1-FDSA4-1A/C. Welder is identified as 052917 ZPMC QC is identified as Wen zhong wan. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-2221-B-U3C-S2.

BAY#11

SAW welding process of weld joint 1A located on PCMK WSD1-A423B/H. Welder is identified as 041716 ZPMC QC is identified as Yun Liao. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S2.

SAW welding process of weld joint 4A located on PCMK WSD1-TL6B/L. Welder is identified as 041716 ZPMC QC is identified as Li hong fei. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S2.

SAW welding process of weld joint 5A located on PCMK ESD1-F-DSA4-2A/D. Welder is identified as 044558 ZPMC QC is identified as Yu Pong Ping. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S2.

Visual Inspection.

This Caltrans Quality Assurance Inspector observed ZPMC personnel performing welding of North Tower, Lift2, Skin A doubler plate weld NSD1-SA166B/F-6 without preheating the weld and adjacent base material. Incident report was issued.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar, Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
